

Work Order ID 78546

78546

Page 1

January-11-12 10:53:50 AM

Item ID: D412-705-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Intake Plenum Access Panel

Stop

NS2

Start Date: 11/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev C

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPPD412-705-013 CHG 002

8/12/02/09

MLJ 12-1-24
(3)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 12-01-24.

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

8/12/02/09

(XB)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78546

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January-11-12 10:53:50 AM

Item ID: D412-705-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Intake Plenum Access Panel
 Start Date: 11/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-705-013 Location: <u>ID</u> PPP Rev: <u>B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12-0210
(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78546

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Parent Item: D412-705-013

D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-09 JLM Verified By:EC
IPP Rev:B ECN 1052 07-11-05 DD Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245-041 Sg *D3245-041* Access Panel Assembly		Manufactured	No			120	Each	4.0000	1	43			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233A				4					
				71674				4					
D3245-042 Sg *D3245-042* Access Panel Assembly		Manufactured	No			120	Each	3.0000	1	43			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233A				3					
				71675				3					
D3245-043 Sg *D3245-043* Door Assembly		Manufactured	No			120	Each	3.0000	2	86			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233B				3					
				76163				3					
D3245-11 Sg *D3245-11* Gasket 9.01		Manufactured	No			120	Each	9.0000	2	86			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST233				9					
				77822				9					

43
SP

3x
43
SP

3x
86
SP 3x 78541 12/2/12

3x
86
SP 12-01-24

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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*Parent Item: D412-705-013

D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3245-13	Manufactured	No	120	Each	24.0000	2	86
D3245-13						**	SP
Gasket 9.50							B 7/1649 2x
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST233	24			
			71642	4			4x
			71649	20			
D3245-9	Manufactured	No	120	Each	20.0000	2	86
D3245-9						**	SP
Gasket 8.35							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST233	20			
			71650	20			Lox
MS20427M3-3	Purchased	No	120	Each	1,204.000	16	64 48
MS20427M3-3						**	SP
Rivet							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST318	1204			
			118384	1204			48x
MS21060-L3K	Purchased	No	120	Each	431.0000	8	32 24
MS21060-L3K						**	SP 12-01-24
Nut Plate							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST303	431			
			120059	40			
			120142	391			24x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
	16	44	36		12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
	8	22	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

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Revision: C

Date: 07.10.12